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NISHIKAWA HIROYUKI****(54) THREAD CUTTING CONTROL SYSTEM****(57) Abstract**

PURPOSE: To recut a rough cut thread in the same phase, by inputting outputs from a read circuit and a phase shift arithmetic circuit to a thread cutting cycle circuit while a tool locus, generated by correcting a phase shift, to a cutting machine.

CONSTITUTION: A sum of a phase shift quantity δ_1 , correction quantity ST of delay time and a Diff quantity SD and a feed quantity F from a read circuit 1 are input to a phase shift arithmetic circuit 9. A true phase shift quantity δ_2 is obtained from the residue of $(\delta_1 + ST + SD)/F$. The circuit 1 and the quantity δ_2 of the circuit 9 are input to a thread cutting cycle circuit 2, and its output is input to a cutting machine 10 via a circuit 3. By this input of a corrected tool locus, a threaded part is recut and finished in the same phase when roughing is performed.

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